

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024705**Date Inspected:** 10-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China**CWI Name:** Mr. SHI LIE**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the bottom plate to bottom plate transverse splice weld joint located on 13AW+13BW. The weld is designated as OBW13B-003. The welder is identified as 045446. ZPMC QC Mr. HU MEI GANG was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-3008.

Segment Tagging of 13AW

2. NDT:

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Magnetic Particle Testing (MT):

MT carried out for the ZPMC submitted Notification No 09432.

This QA Inspector randomly witnessed and performed Magnetic Particle Testing (MT) of approximately 15% of the area that has been previously tested and accepted by ZPMC MT technicians. This QA Inspector generated a TL-6028 MT report on this date. The members are identified as fillet & complete joint penetration weld joint located on 13AW at Blast shop-4. The weld designation numbers is as follows:

1. SEG3013P-132
2. SEG3013P-133
3. SEG3013P-138
4. SEG3013P-139
5. SEG3013R-034
6. SEG3013R-035
7. SEG3013R-036
8. SEG3013R-037
9. SEG3013R-038
10. SEG3013R-039
11. SEG3013R-040
12. SEG3013R-041
13. SEG3013R-042
14. SEG3013R-043
15. SEG3013R-044
16. SEG3013R-045
17. SEG3013R-046
18. SEG3013R-047
19. SEG3013R-048
20. SEG3013R-049
21. SEG3013X-379
22. SEG3013X-381
23. SEG3013X-395
24. SEG3013X-403
25. SEG3013X-407
26. SEG3013X-409
27. SEG3013X-418
28. SEG3013X-553
29. SEG3013X-554
30. SEG3013X-555.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
